

May-22-12 2:58:57 PM

84745

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Emergency Escape Ladder

Start Date: 22/05/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 05/06/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/22 Tooling:

Date:

Run Start. *NR1*

QC:

Date: _____ **SPC (Y/N):** _____

Date:

Stop *NR2*

Draw Nbr	Revision Nbr
D4617	B

100

0.00

100

CNC Bend 1

CNC Delta 100 Bender

Memo

0,00

BEND RAIL AS PER DWG AND TO FIT PROFIL OF WELDING JIG DT9803
(ON LENGTH OF TUBE, 20 FEET MAKES 2 RAILL)

110

Weld per dwg A/R 4130 rod Batch: M 118875 0.00

0.00

110

Large Fab

Large Fab

Memo

0.00

1- CUT STEPS AS PER DWG AND PREP FOR WELDING

2- CUT RAIL

3- INSTALL PARTS ON WELDING JIG DT9803 AND WELD AS PER DWG

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84745

84745

Page 2

May-22-12 2:58:57 PM

Item ID: D4617-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Emergency Escape Ladder
 Start Date: 22/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1x		6/12-06-19	
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1x		6/12-06-19	
140 *140* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 84745

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Page 3

May-22-12 2:58:57 PM

Item ID: D4617-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Emergency Escape Ladder
 Start Date: 22/05/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating M113645	Fire Red(Ref:4.3.5.10) per QSI005 4.3 Memo START TIME: 1-30 OVEN TEMPERATURE: 320°F FINISH TIME: 2-00	0.00				IX	Ø		M-F 12/06/20
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00							IX & M 12/06/20
170 *170* Small Fab Small Fab	1- Assemble clamps, clamps cover and tube caps to ladder as per dwg 2- Install decals as per dwg	0.00				I			FF 13-01-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 84745

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Page 4

May-22-12 2:58:57 PM

Item ID: D4617-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Emergency Escape Ladder
 Start Date: 22/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180	QC5- Inspect part completeness to step on W/O	0.00				1			
180									
QC	Memo	0.00							
Quality Control									

190		0.00							
190									
Packaging	Memo	0.00							
Packaging									

200	Identify as per dwg & Stock Location: _____	0.00							
200									
Packaging	Memo	0.00							
Packaging									

PRP 84116

ME
13-1-15

Dart Aerospace Ltd

W/O: 8474		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
2007 130128	190	N / A						

Part No: D 4617-04/ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 2:59:01 PM

Page 1

Work Order ID: 84745

84745

Parent Item: D4617-041

D4617-041

Parent Item Name: Emergency Escape Ladder

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4130NT0.750W.035
Purchased No
M4130NT0 750W 035
4130 RD TUBE .750 X .035W

Location	Loc Qty	Loc Code
MAT032	57.62	
121250	57.62	

M4130NT0.750W.035
Purchased No
M4130NT0 750W 035
4130 RD TUBE .750 X .035W

Location	Loc Qty	Loc Code
MAT032	57.62	
121250	57.62	

D4617-045
Manufactured No
D4617-045
Clamp Assembly

D4618-041
Manufactured No
D4618-041
Clamp Assembly Cover

Location	Loc Qty	Loc Code
ST187	2	
83121	2	

D4621-1
Manufactured No
D4621-1
Decal

Location	Loc Qty	Loc Code
ST116	6	
83682	6	

**
21.05263
20
12-6-17

**
5.326316
5.06
20'
12-6-17

**
4
4
FF 13-01-15

**
4
4
FF 13-01-15

**
2
2
2
FF 13-01-15

**
2
2
FF 13-01-15

use 212-11011
D4621-1
22 13.06.15
108100 x1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

May-22-12 2:59:01 PM

Page 2

Work Order ID: 84745

84745

Parent Item: D4617-041

D4617-041

Parent Item Name: Emergency Escape Ladder

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4621-3 Manufactured No

170 Each 21.0000 1 1

D4621-3

Decal

**

FF 13-01-15

Location

Loc Qty

Loc Code

ST 95580
83683

6

6

ST116

15

83683

15

D4625-1 Manufactured No

170 Each 92.0000 4 4

D4625-1

Tube Cap

**

FF 13-01-15

Location

Loc Qty

Loc Code

ST115
ST 83122

92

92

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

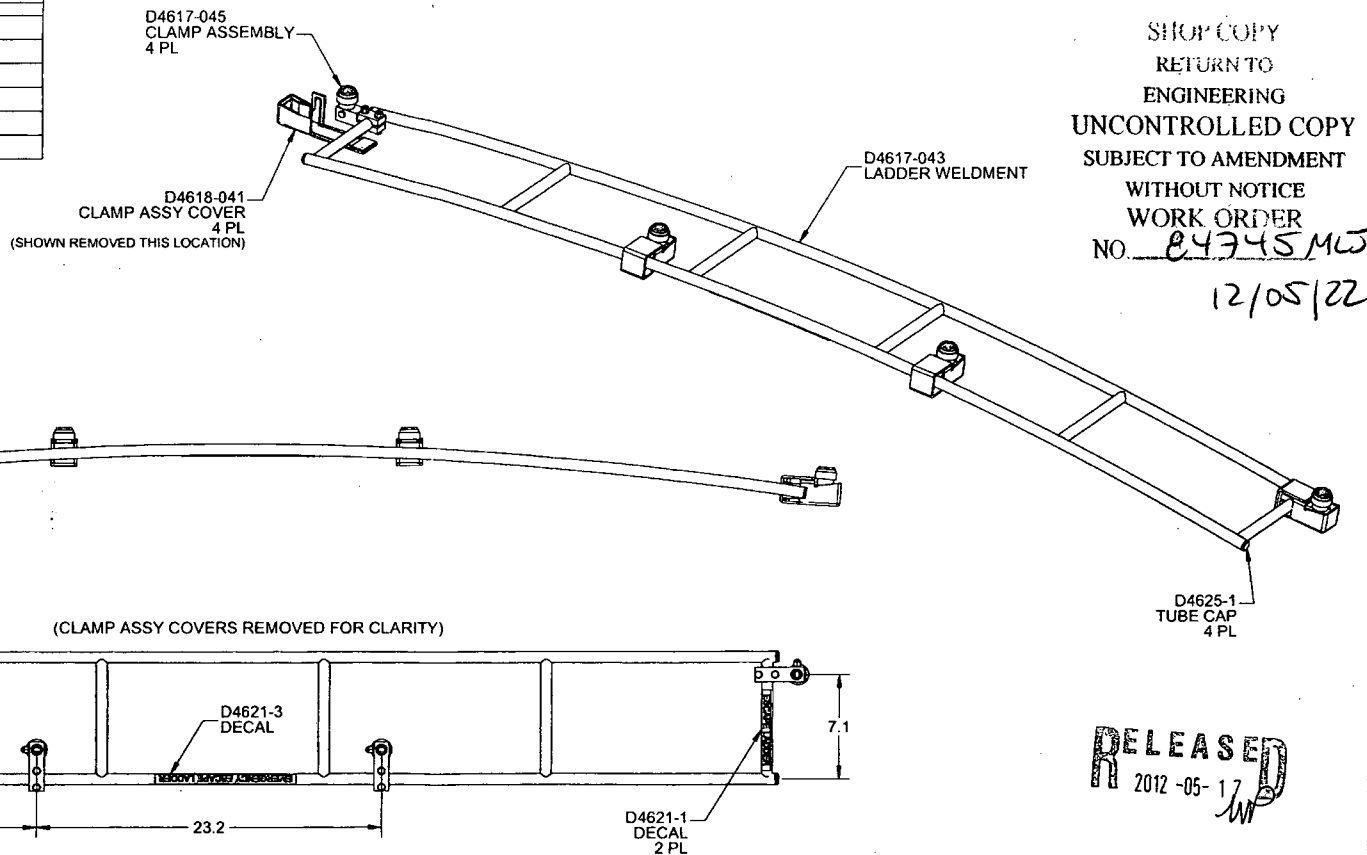
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4617-041	EMERGENCY ESCAPE LADDER
1	1	D4617-043	LADDER WELDMENT
2	4	D4617-045	CLAMP ASSY
3	4	D4618-041	CLAMP ASSY COVER
4	2	D4621-1	DECAL
5	1	D4621-3	DECAL
6	4	D4625-1	TUBE CAP



D4617-041 EMERGENCY ESCAPE LADDER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4617-041" AND BATCH NUMBER PER QSI044 6.6
- 7) WEIGHT: 6.48 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84745 ML
12/05/22

RELEASED
2012-05-17

B	75.4-75.5 WAS 75.7 (C1-2) WASHER WAS NAS1149C0463R, QTY 3 ON SHT 4. 0.753-0.756 WAS 0.750-0.753 (B4-5)	RP	12.05.01
A	NEW ISSUE	RP	12.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D4617	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		EMERGENCY ESCAPE LADDER	NTS
DATE	12.05.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

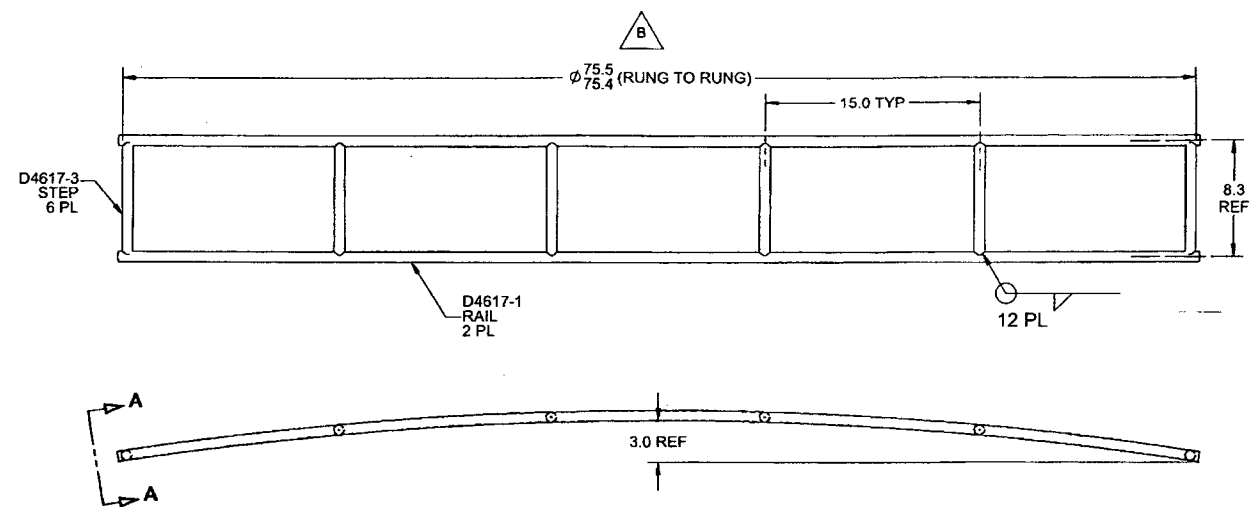
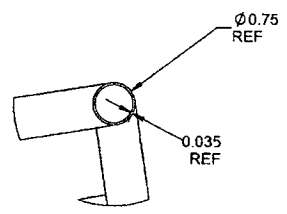
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84745



D4617-3
STEP
6 PL

D4617-1
RAIL
2 PL

D4617-043 LADDER WELDMENT

RELEASED
2012-05-17
W

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART QSI044 6.6
 - 7) WEIGHT: 4.5 lbs
 - 8) WELDING: PER DART QSI 004

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D4617	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		EMERGENCY ESCAPE LADDER	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

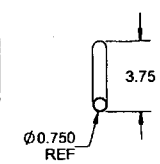
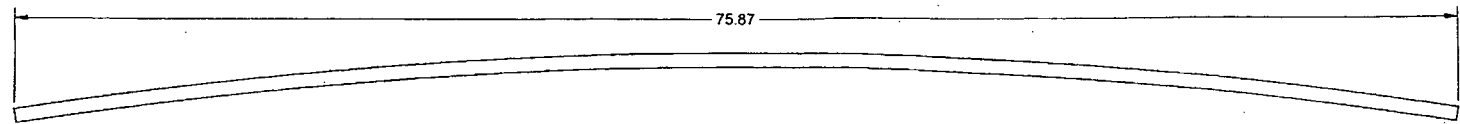
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

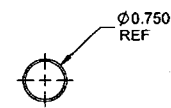
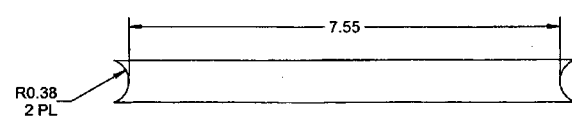
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84745



D4617-1 RAIL



D4617-3 STEP

RELEASED
2012-05-17

- NOTES:**
- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T8736
OR AMS6371, 6360, 6361, 6362, 6373, 6374
REF DART SPEC M4130NT0.750W.035
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART QSI044 6.6
 - 7) WEIGHT: D4617-1 1.7lbs
D4617-3 0.17lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AP	DRAWING NO. D4617	REV. B
MFG. APPR.	AP		SHEET 3 OF 5
APPROVED	AP	TITLE EMERGENCY ESCAPE LADDER	SCALE NTS
DE APPR.	AP	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	12.05.01		

W/O:		WORK ORDER CHANGES						
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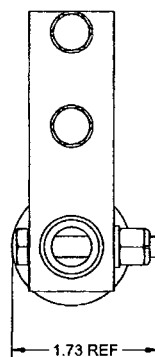
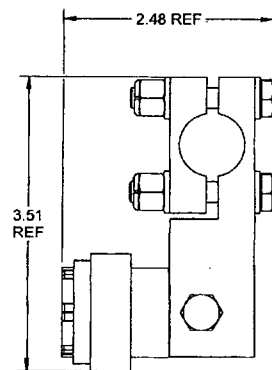
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

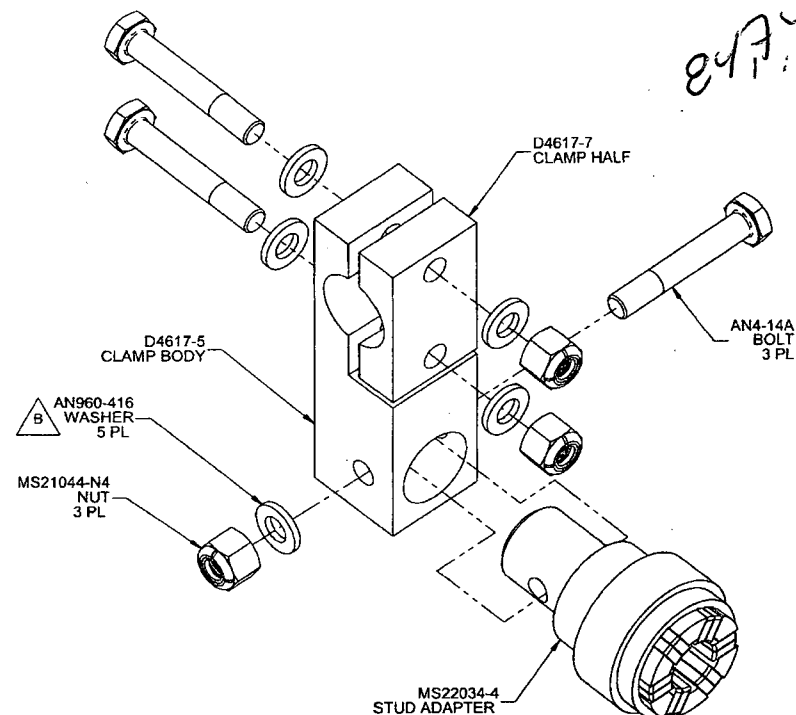
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ITEM	QTY	P/N	DESCRIPTION
	X	D4617-045	CLAMP ASSEMBLY
1	1	D4617-5	CLAMP BODY
2	1	D4617-7	CLAMP HALF
3	3	AN4-14A	BOLT
4	5	AN960-416	WASHER
5	3	MS21044-N4	NUT
6	1	MS22034-4	STUD ADAPTER





D4617-045 CLAMP ASSY



RELEASED
2012-05-17

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: 0.5 lbs

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. B
MFG. APPR.		D4617	SHEET 4 OF 5
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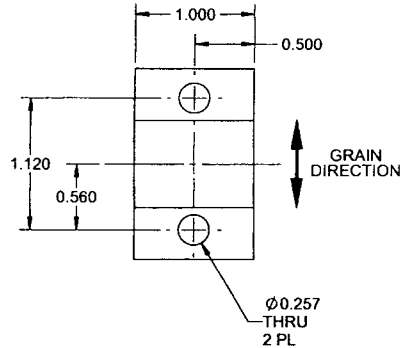
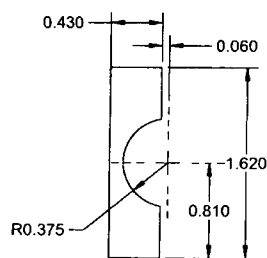
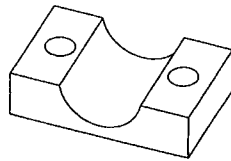
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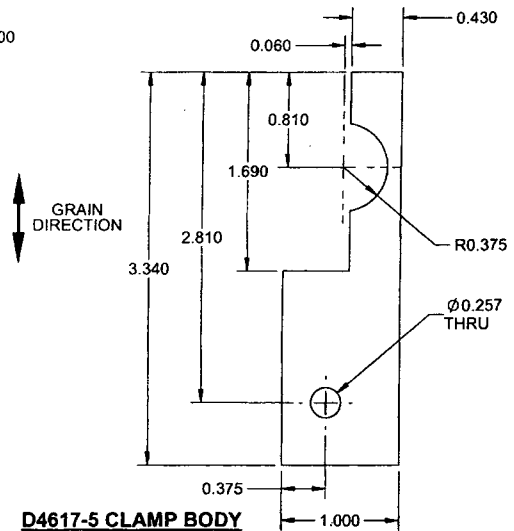
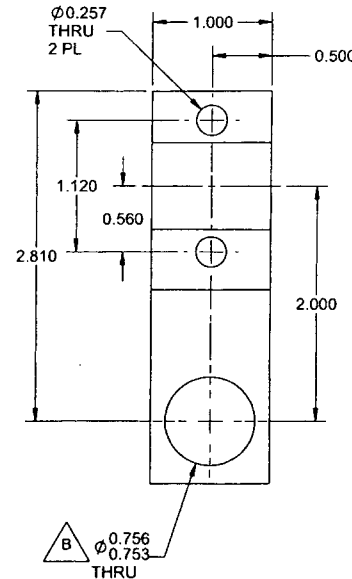
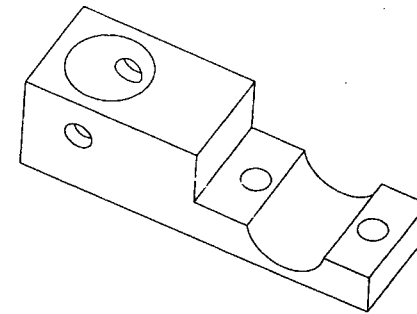
NOTE: Date & initial all entries



D4617-7 CLAMP HALF

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR
AMS 4117/4128/4115/4116 OR QQ-A-200/8
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: D4617-5 0.17 lbs
D4617-7 0.05 lbs
- 8) POSSIBLE SUPPLIER: D4617-5: EAGLE P/N 212-110-06
D4617-7: EAGLE P/N 212-110-07



D4617-5 CLAMP BODY

RELEASED
2012-05-17

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4617	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE EMERGENCY ESCAPE LADDER	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	SCALE NTS	
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DATE	12.05.01		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries